

Pick and ship ASAP.

Work Order ID 143979

143979

Page 1

March 29, 2016 9:04:33 AM

Item ID: DSI 9464-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube Tuning

Start Date: 3/29/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/4/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: SH

Date: 20160329

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3955

A

DSI 9464

B

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP DSI 9464-011
CHG001

DAS
27
9-89

APR 04 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

MAR 31 2016

DAS
28
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

Work Order ID 143979***143979***

Page 2

March 29, 2016 9:04:33 AM

Item ID: DSI 9464-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube Tuning
Start Date: 3/29/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/4/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00				BAS 27 9-89			
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130									
Packaging	Memo	0.00				BAS 27 9-89			
Packaging	Identify and pack for shipping as per PPP DSI 9464-011 Location : FG122								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

APR 04 2016

APR 04 2016

APR 04 2016

APR 04 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

March 29, 2016 9:04:38 AM

143979

DSI 9464-011

Start Date: 3/29/2016**Required Date:** 4/4/2016**Start Qty: 1.00**

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
per ECN10-553 DD 10.04.19 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3955-041 *D3955-041* Doubler Assembly		Manufactured	No			110	Each	2.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST064		2							
				101919		1							
				135572		1							
D3955-3 *D3955-3* Cover Plate		Manufactured	No			110	Each	4.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST063		4							
				134118		4							
D3955-5 *D3955-5* Plate		Manufactured	No			110	Each	2.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST064		2							
				134119		2							
D3955-7 *D3955-7* Plate		Manufactured	No			110	Each	2.0000	6	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST064		2							
				134120		2							

Picklist Print

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Page 2

Work Order ID: 143979

143979

Parent Item: DSI 9464-011

DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 3/29/2016

Required Date: 4/4/2016

Start Qty: 1.00

Required Qty: 1.00

D3955-21

Manufactured No

110

Each

4.0000

2 / 2

D3955-21

Gasket

**

MLJ MAR 31 2016

DAS
28
9-89

BAS
27
9-89

Location

Loc Qty

Loc Code

ST064

4

134121

4

2

D3955-23

Manufactured No

110

Each

4.0000

2 / 2

D3955-23

Template

**

MLJ MAR 31 2016

DAS
28
9-89

BAS
27
9-89

Location

Loc Qty

Loc Code

ST064

4

134122

4

2

CR3212-4-04

Purchased No

110

Each

357.0000

38 / 38

CR3212-4-04

Cherry Rivet

**

MLJ MAR 31 2016

DAS
28
9-89

BAS
27
9-89

Location

Loc Qty

Loc Code

CCK005

100

m133077

100

LG001

40

m126534

40

ST320

217

m132317

17

m134365

200

38

Picklist Print

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Page 3

Work Order ID: 143979

143979

Parent Item: DSI 9464-011

DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 3/29/2016

Required Date: 4/4/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-5A

Purchased

No

110

Each

404.0000

4

4

AN3-5A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

34

m133686

2

m134055

32

GA

4

m133686

4

ST350

366

m134055

66

m134502

300

MLJ MAR 31 2016

DAS
28
9-89

AN3-6A

Purchased

No

110

Each

273.0000

4

4

AN3-6A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

over003

175

M134055

175

ST349

98

M133932

98

MLJ MAR 31 2016

DAS
28
9-89

AN3-7A

Purchased

No

110

Each

189.0000

4

4

AN3-7A

Bolt

DAS
-27
9-89

Location

Loc Qty

Loc Code

over003

100

m133694

100

ST349

89

M129507

37

m132763

46

m132803

6

MLJ MAR 31 2016

DAS
28
9-89

March 29, 2016 9:04:38 AM

Shop Packet Print

Page 3

Picklist Print

March 29, 2016 9:04:38 AM

Page 4

Work Order ID: 143979

143979

Parent Item: DSI 9464-011

DSI 9464-011

Parent Item Name: Skidtube Tuning

Start Date: 3/29/2016

Required Date: 4/4/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-10A Purchased No

110 Each 181.0000 4 4

AN3-10A

Bolt

MLJ

MAR 31 2016

Location

Loc Qty

Loc Code

GA	1
m132763	1
over003	100
m134249	100
ST349	80
m133992	80

DAS
28
9-89

DAS
27
9-89

NAS1149D0332J Purchased No

110 Each 1,822.000 6 6

NAS1149D0332.J

Washer

MLJ

MAR 31 2016

Location

Loc Qty

Loc Code

CA	10
m129682	10
GA	110
m132677	110
ST260a	1600
m133988	600
m134502	1000
ST266	102
m133498	102

DAS
28
9-89

DAS
27
9-89

DART SERVICE INSTRUCTION

TO AMEND:

INSTALLATION INSTRUCTIONS D205-634 REV. F OR EARLIER,
INSTALLATION INSTRUCTIONS D204-635 REV. F OR EARLIER,
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-634 REV. 3 OR EARLIER,
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D204-635 REV. 3 OR EARLIER

REF CANADIAN STC: SH96-88
REF FAA STC: SR00563NY
REF EASA STC: EASA.IM.R.S.01303

Purpose:

The Purpose of the DSI 9464-011 Kit is to allow operators to tune landing gear utilizing D205-634-041 / D204-635-041 skidtube in order to eliminate vibration. This kit consists of various weights that can be attached to the fwd cap of the Dart skidtube.

Procedure:

Note: Installer must be careful not to damage underlying skidtube during drilling operations.

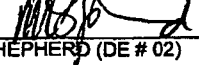
- 1) Locate D3955-23 template on the fwd cap of the skidtube. Transfer drill 19 x Ø0.098" holes from the D3955-23 template to the skidtube cap using a #30 drill.
- 2) Transfer drill 1 x Ø0.625" (15.8 mm) from the D3955-23 template to the skidtube as shown in Figure 1.
- 3) Transfer drill 1 x Ø0.201" (#7 drill) from the D3955-23 template to the skidtube as shown in Figure 1.
- 4) Deburr the drilled holes in fwd cap. Ensure the top surface of the cap is clear of debris.
- 5) Apply a layer of Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant between the D3955-041 Doubler and the existing skidtube cap. Install D3955-041 Doubler Assy. using 19 x CR3212-4-04 rivets as shown in Figure 1. The nutplate in the D3955-041 Doubler Assy should pass thru the Ø0.625 hole in the cap.
- 6) Install tuning plates as shown in Figure 2. Torque AN3 bolts 15-25 in-lb (1.7-2.8 N-m). Test the landing gear for vibration.
- 7) If vibration persists, repeat step 6 until vibration is eliminated.
- 8) Update Weight & Balance as outlined below.

Weight And Balance:

The weight and balance increase associated with the installation of the DSI 9464-011 kit will depend on the number of plates that are installed to tune the gear. The weight of individual plates are given in the Parts List Table. The longitudinal arm for the installation of the DSI 9464-011 kit is 40.0 in (1.02 m) on 205/210/212/214/412 models and 42.0 in (1.07 m) on 204 models.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

20160329
SA 143979

B	ADD REF TO D204-635	CP	10.04.14
A	NEW ISSUE	RF	09.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9464	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
DATE	10.04.14	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

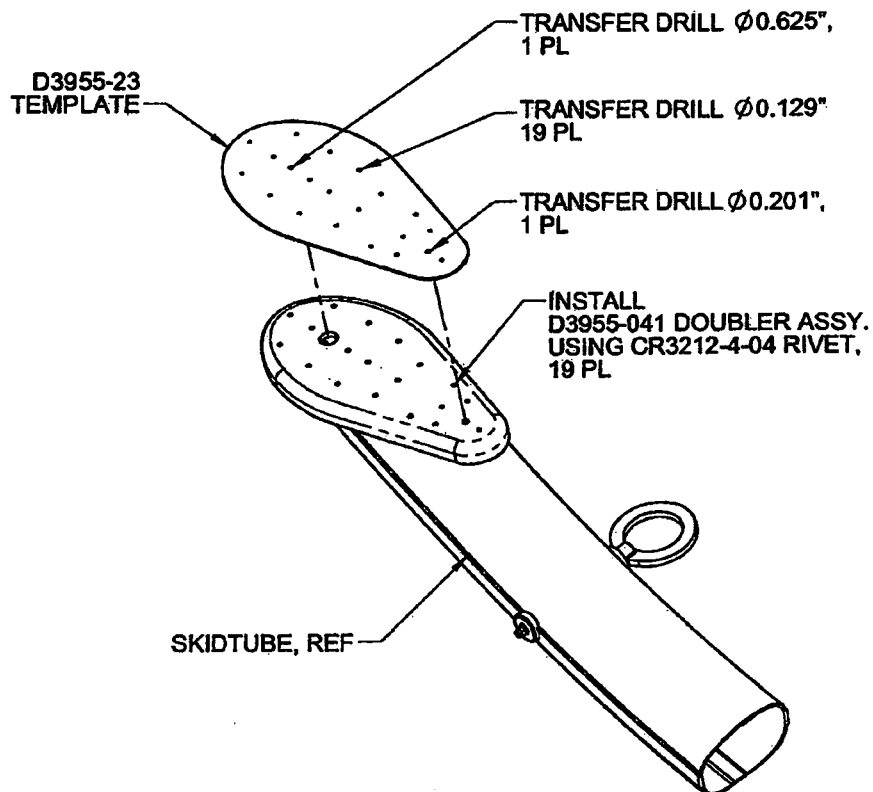


Figure 1

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9464	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE TUNING KIT	NTS
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Part List

Qty -011	Part Number	Description	Weight
X	DSI 9464-011	SKIDTUBE TUNING KIT	N/A
2	D3955-041	DOUBLER ASSEMBLY	0.25 lb/ 0.11 kg
2	D3955-3	COVER PLATE	0.64 lb/ 0.29 kg
2	D3955-5	0.063" THICK PLATE	0.64 lb/ 0.29 kg
6	D3955-7	0.125" THICK PLATE	1.28 lb/ 0.58 kg
2	D3955-21	GASKET	0.08 lb/ 0.04 kg
2	D3955-23	TEMPLATE	N/A
38	CR3212-4-04	RIVET	N/A
4	AN3-5A	BOLT	N/A
4	AN3-6A	BOLT	N/A
4	AN3-7A	BOLT	N/A
4	AN3-10A	BOLT	N/A
6	NAS1149D0332J	WASHER	N/A
2	MS21042L3	NUT (OR MS21042-3)	N/A

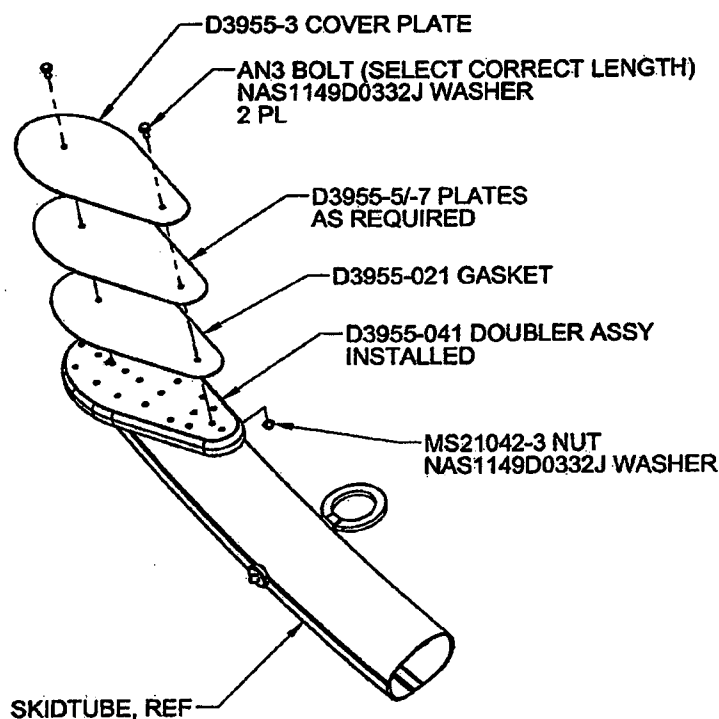


Figure 2

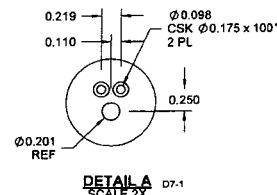
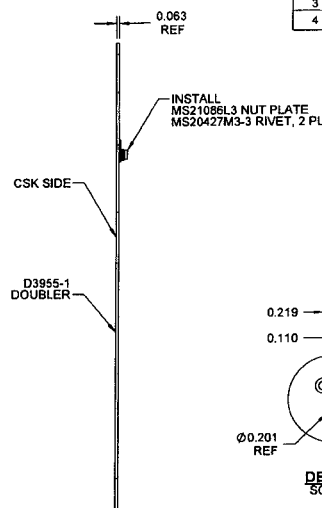
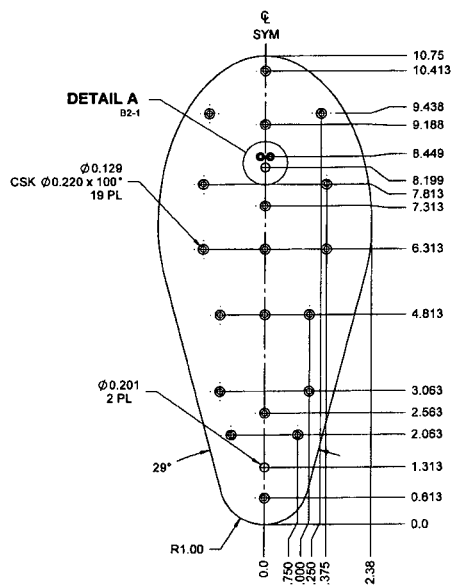
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	RF	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9464	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
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ITEM	QTY	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET



D3955-1 DOUBLER

- D3955-1 NOTES:**
- 1) MATERIAL: 8061-T8 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T8.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.25 lbs

D3955-041 DOUBLER ASSEMBLY

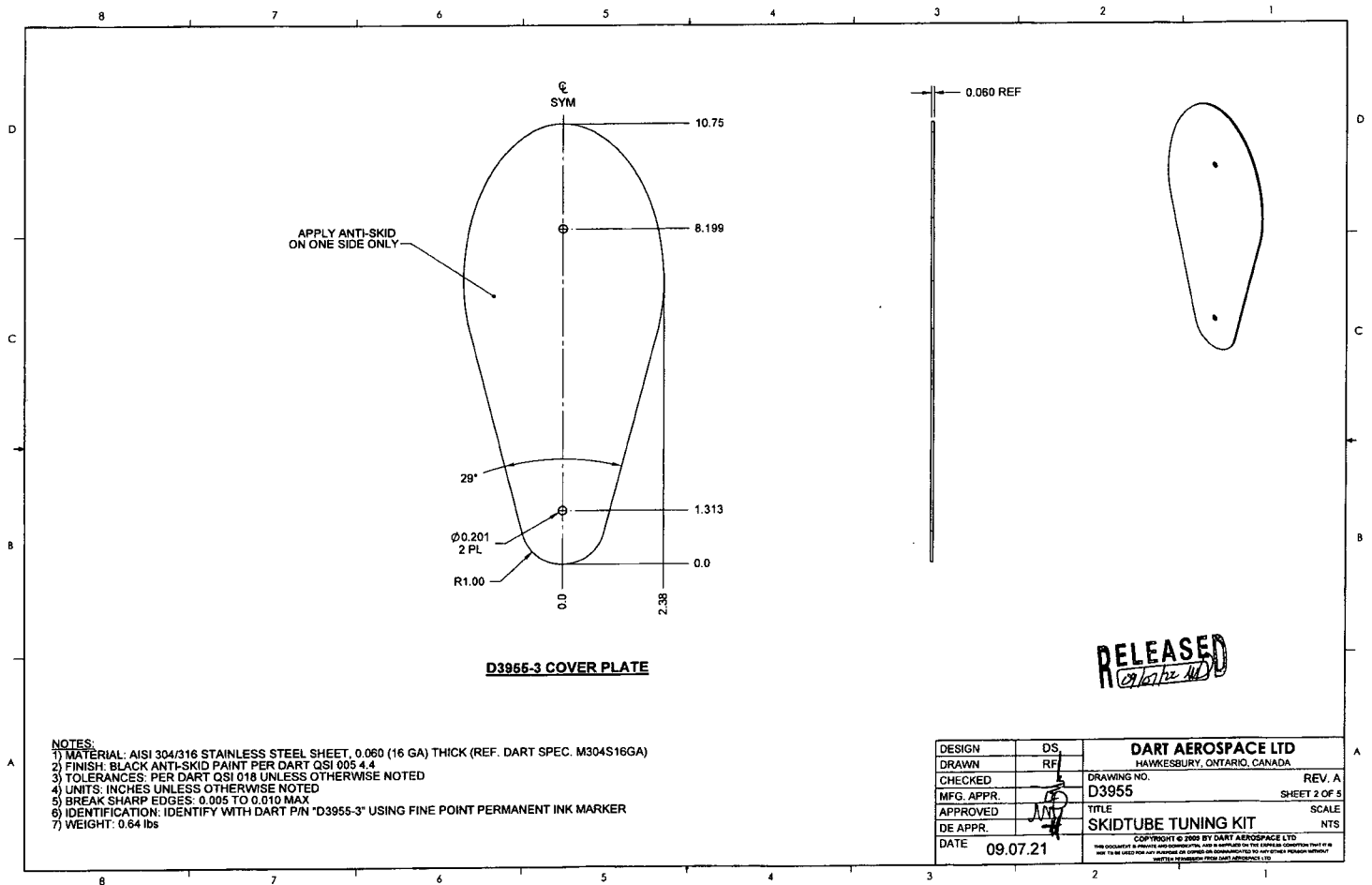
20160329 RELEASED
SA 143979

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	RF	09.07.21
DESIGN	DS		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.21		

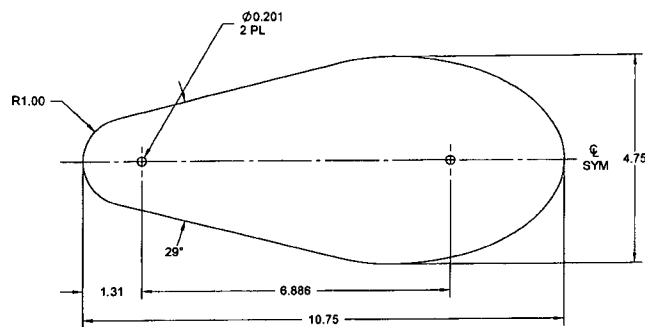
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3955
SHEET 1 OF 5
TITLE SKIDTUBE TUNING KIT
NTS

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RELEASED
09/07/21



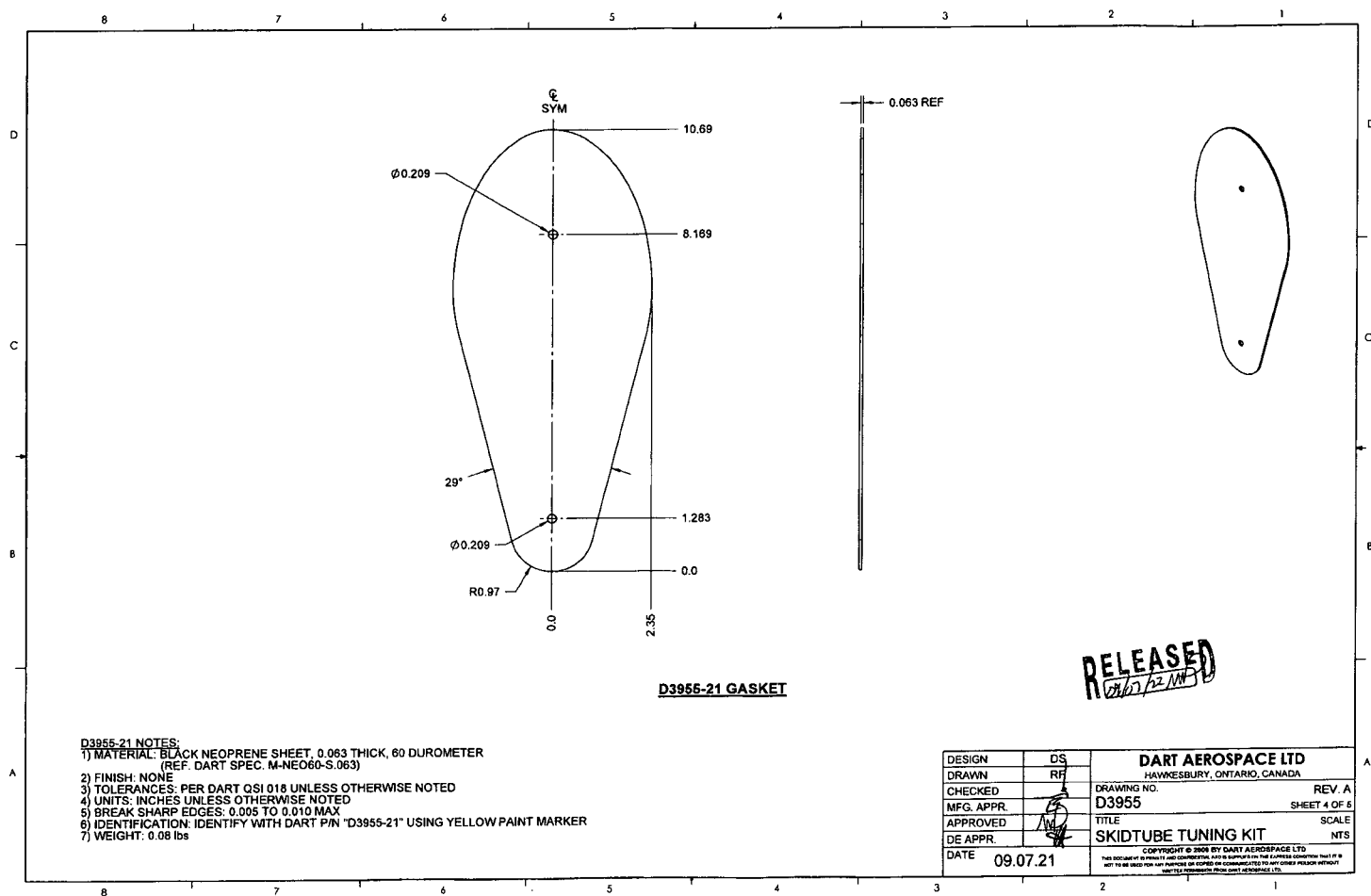
D3955-X PLATE

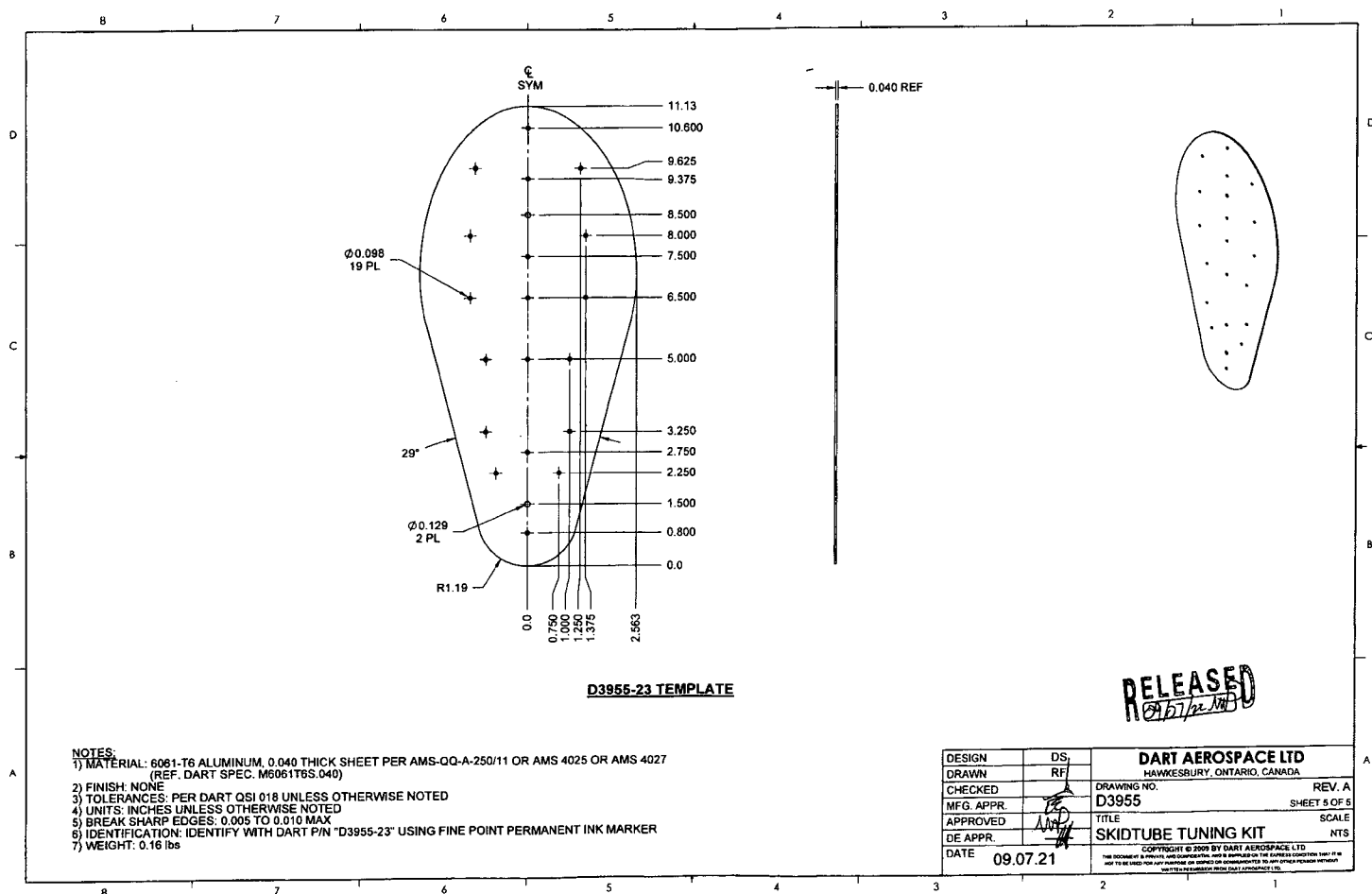
General Table			
P/N	T (in)	T (GA)	WEIGHT (lbs)
D3955-5	0.080	16	0.64
D3955-7	0.120	11	1.28

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304ST/GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: SEE TABLE

RELEASED
01/20/22 MJD

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
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RELEASED
21/07/21 MTD

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
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Part List

Qty -011	Part Number	Description	Weight
X	DSI 9464-011	SKIDTUBE TUNING KIT	N/A
2	D3955-041	DOUBLER ASSEMBLY	0.25 lb/ 0.11 kg
2	D3955-3	COVER PLATE	0.64 lb/ 0.29 kg
2	D3955-5	0.063" THICK PLATE	0.64 lb/ 0.29 kg
6	D3955-7	0.125" THICK PLATE	1.28 lb/ 0.58 kg
2	D3955-21	GASKET	0.08 lb/ 0.04 kg
2	D3955-23 *	TEMPLATE	N/A
38	CR3212-4-04	RIVET	N/A
4	AN3-5A	BOLT	N/A
4	AN3-6A	BOLT	N/A
4	AN3-7A	BOLT	N/A
4	AN3-10A	BOLT	N/A
6	NAS1149D0332J	WASHER	N/A
2	MS21042L3	NUT (OR MS21042-3)	N/A

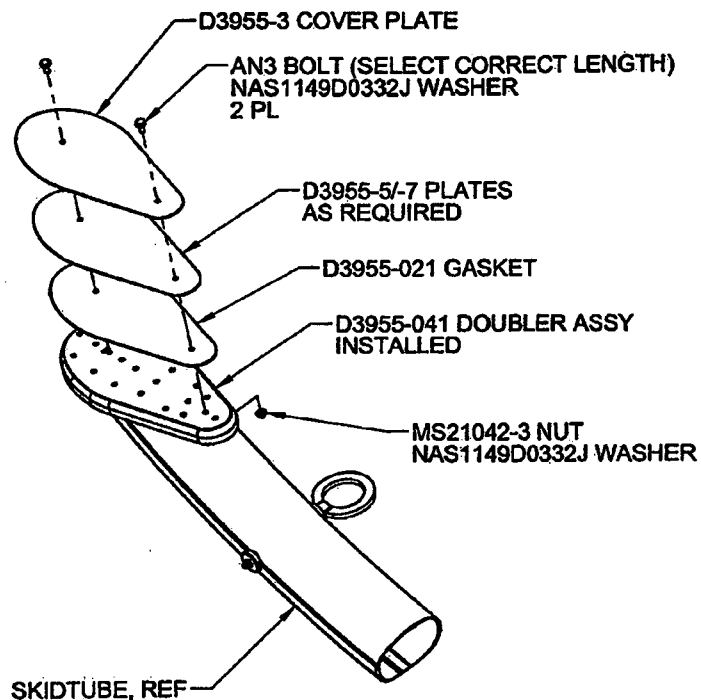


Figure 2

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.04.14
CERT. NO.: SH96-88
ISSUE NO.: 3

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DE APPR.	1/10/14	SKIDTUBE TUNING KIT	NTS
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